



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D212-664-201TRN
Job Sheet 173489



Part No: D212-664-201TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 Removed polish EC verified DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/15/18	3/15/18	0.00	0.00	Start Up Crosstubes-2		PMP
100	Mori Seiki	1 pcs	3/15/18	3/15/18	0.00	1.33	Mori Seiki TL-40		PMP
110	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC1 QC2		PMP
120	Mori Seiki	1 pcs	3/15/18	3/15/18	0.00	1.33	Mori Seiki TL-40		PMP
130	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC1 QC2		PMP
140	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC8		PMP
145	Crosstubes	1 pcs	3/15/18	3/15/18	0.00	0.25	Crosstubes-2		W
150	HandFXtube	1 pcs	3/16/18	3/16/18	0.00	0.25	Crosstubes-3		SA 18-01-09
160	QC	1 pcs	3/16/18	3/16/18	0.00	0.00	QC7-1		JK
170	Packaging	1 pcs	3/16/18	3/16/18	0.00	0.00	Packaging3-1		JK
180	QC21-SA	1 Ea	3/16/18	3/16/18	0.00	0.00	QC21		21 9-80 APR 25 2018

Part Op 100 - 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114 2-Turn first side as per Folio FA114
 Descriptions: 120 - 1-Turn second side as per Folio FA114
 145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
 150 - 1- handfinish X-TUBE INSIDE AND OUT
 170 - Identify and stock in kanban rack Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6006-129	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6006-129	1	71	0

B23 969

Part Specifications

Specifications could not be found.

Plex 3/2/18 10:49 AM Dart.Gagnon.Michelle



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Container No: S048942



Part: D212-664-201TRN

Job No: 173489

Serial No/Batch: S048942

Revision:

Inspector:

Date: 03/08/18

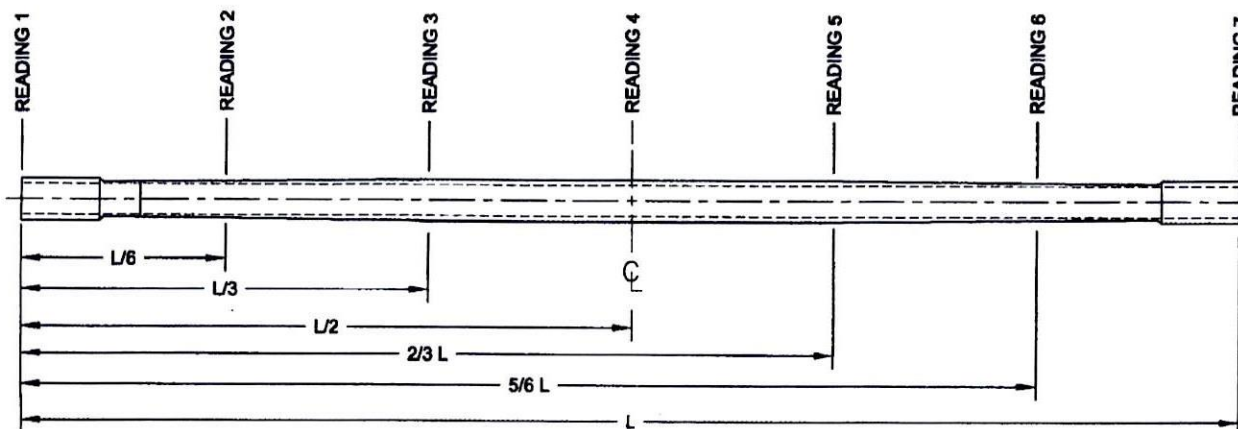
DART AEROSPACE LTD		Work Order:	173489
Description: Crosstube Assembly (205/212 High Aft)		Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.190	✓	VERNO8	
	R0.063	+/-0.010	.063	✓	RG	
	2.990	+0.005/-0.000	2.992	✓	VERNO8	
	5.237	+/-0.030	5.235	✓	"	
	2.600	+0.005/-0.000	2.605	✓	ALM 2"-3"04	
	2.686	+0.005/-0.000	2.691	✓	"	
	2.770	+0.005/-0.000	2.775	✓	"	
	2.854	+0.005/-0.000	2.859	✓	"	
	2.938	+0.005/-0.000	2.9425	✓	"	
	3.021	+0.005/-0.000	3.025	✓	ALM 3"-4"05	
	3.133	+0.005/-0.000	3.1365	✓	"	
	3.179	+0.005/-0.000	3.1825	✓	"	
	.500	±.010	.500	✓	RG	
	.063	±.010	.063	✓	RG	
	0.200	+/-0.010	.192	✓	VERNO8	
SIDE B	R0.063	+/-0.010	.063	✓	RG	
	2.990	+0.005/-0.000	2.992	✓	VERNO8	
	5.237	+/-0.030	5.240	✓	"	
	2.600	+0.005/-0.000	2.605	✓	ALM 2"-3"04	
	2.686	+0.005/-0.000	2.691	✓	"	
	2.770	+0.005/-0.000	2.775	✓	"	
	2.854	+0.005/-0.000	2.8585	✓	"	
	2.938	+0.005/-0.000	2.9425	✓	"	
	3.021	+0.005/-0.000	3.0255	✓	ALM 3"-4"05	
	3.133	+0.005/-0.000	3.1365	✓	"	
	3.179	+0.005/-0.000	3.1825	✓	"	
	124.362	+/-0.020	124.360	✓	TAPE	
	.500	±.010	.500	✓	RG	
	.063	±.010	.063	✓	RG	

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	383	377	416	421	.044	0.062"
READING 2 L= 20.73	319	304	326	341	.037	
READING 3 L= 41.45	494	476	484	502	.026	
READING 4 L= 62.18	528	505	508	541	.036	
READING 5 L= 82.91	502	474	472	512	.040	
READING 6 L= 103.64	332	314	310	335	.025	
READING 7 L= 124.36	395	391	406	415	.024	

Calibration Result

Actual Block Thickness: 200-500

Sitiescan 250 Measured Thickness: 200-500

Measured by: PMP	Audited by: JTW	Preliminary Approval:
Date: 2018-03-07	Date: 18-03-12	Date:

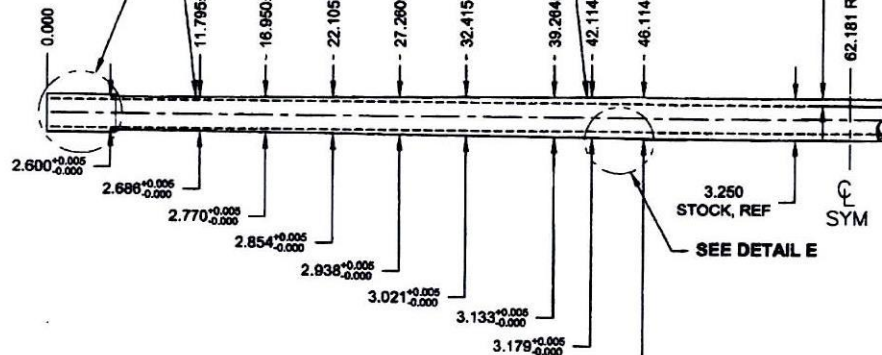
Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ	
E	12.06.04	Wall thickness form added	KJ	
F	15.03.03	Dwg Rev updated	KJ	

R100.0 TRANSITION
BETWEEN TAPERED
SECTIONS

R100.0 TRANSITION
BETWEEN TAPERED
SECTIONS

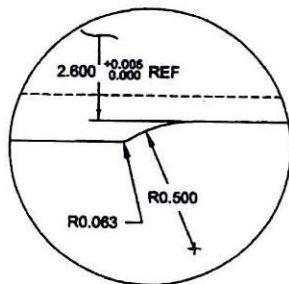
0.515 WALL
STOCK, REF

SEE DETAIL D

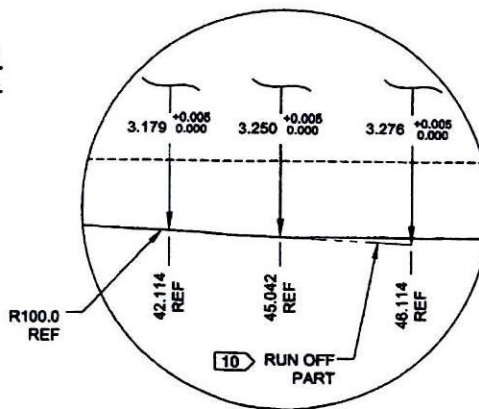


10 3.179^{+0.005}/_{-0.000} TAPER UNIFORMLY FROM
THROUGH TO 3.276^{+0.005}/_{-0.000}
RUNNING OFF PART

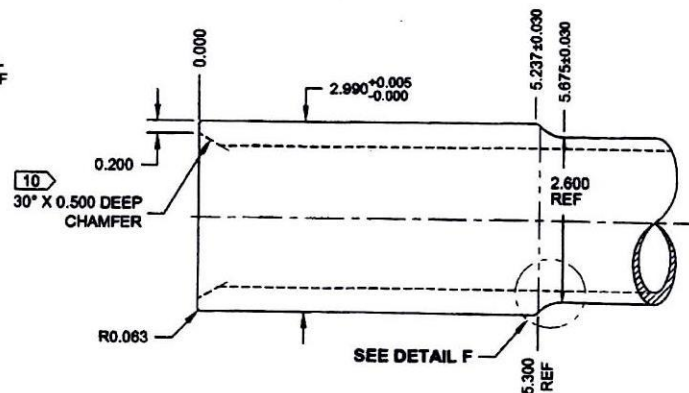
D212-664-241TRN
TURNING DETAIL



DETAIL F:
CUFF TRANSITION
SCALE 10X



DETAIL E:
TAPER RUN-OFF
NOT TO SCALE



DETAIL D:
CROSSTUBE CUFF
SCALE 5X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173489
MAR 02 2018

RELEASED
2014-05-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D212-664-241	REV. E
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
DE APPR.		DATE 14.04.01	

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